

# Work Order ID 78329

January-05-12 10:39:31 AM

**\*78329\***

Page 1

Item ID: D4034-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Upper Rib Assembly

Stop **\*NS2\***

Start Date: 05/01/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 11/01/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/05 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4034

B

100 Weld per dwg A/R S.S. rod Batch: 1115338 0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

12.03.12 (3x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Memo

0.00

Quality Control

12.03.12

3x

120

QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC

Memo

0.00

Quality Control

12/13/12

(3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*78329\***

January-05-12 10:39:31 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 05/01/2012      **Start Qty:** 3.00

**Required Date:** 11/01/2012      **Req'd Qty:** 3.00

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Identify as per dwg & Stock Location:

0.00

**\*130\***

Basket cell  
Memo

0.00

## Packaging

## Packaging

140	QC21- Final Inspection - Work Order Release	0.00
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**\*140\***

QC

## Memo

0.00

## Quality Control

12/3/12 

112-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-05-12 10:39:34 AM

Page 1

Work Order ID: 78329

\*78329\*

Parent Item: D4034-043

\*D4034-043\*

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 05/01/2012

Required Date: 11/01/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
PER DWG REV.B DD VERF:EC  
IPP Rev:B as  
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 <b>*D4034-1*</b> Rib		Manufactured	No			100	Each	3.0000	1	3			
										**	B78262 → 3x		
												Sy 12.03.09	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-05-12 10:39:34 AM

Page 2

Work Order ID: 78329

\*78329\*

Parent Item: D4034-043

\*D4034-043\*

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 05/01/2012

Required Date: 11/01/2012

Start Qty: 3.00

Required Qty: 3.00

D4021-7

Manufactured No

100

Each

2.0000

1

3

✓ \*D4021-7\*

Hoop

\*\*

B79877 → 3x

Location

Loc Qty

Loc Code

WA005

2

74807

2

12.03.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

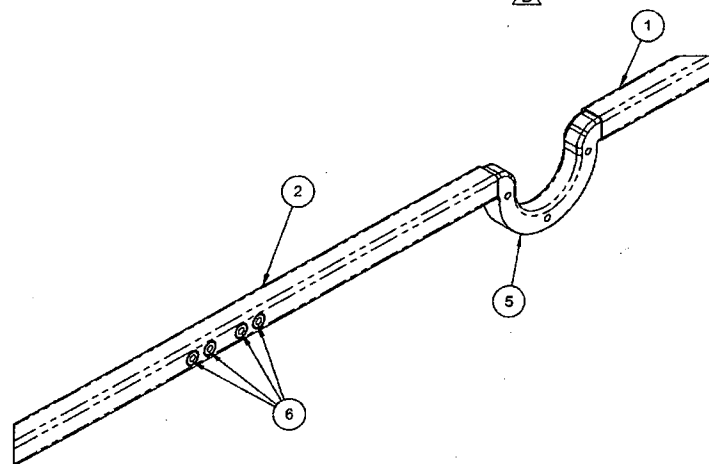
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

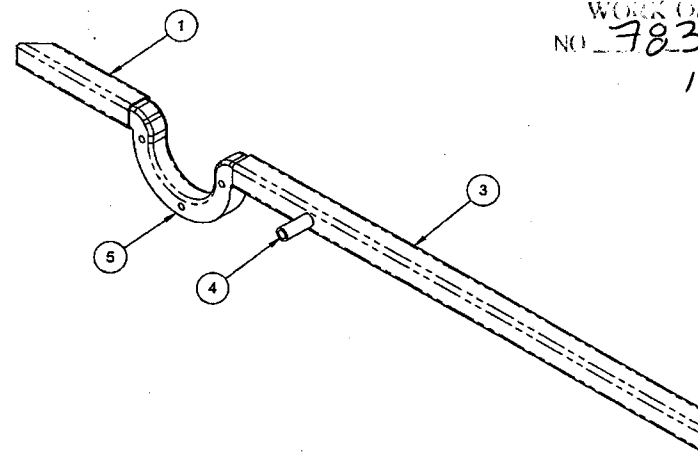
**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



**D4034-041 AFT UPPER RIB ASSY**



**D4034-043 FWD UPPER RIB ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO CHANGE

WORK ORDER  
NO. 78329 M.C.U  
12/01/05

**RELEASED**  
R 2011-01-18  
M

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

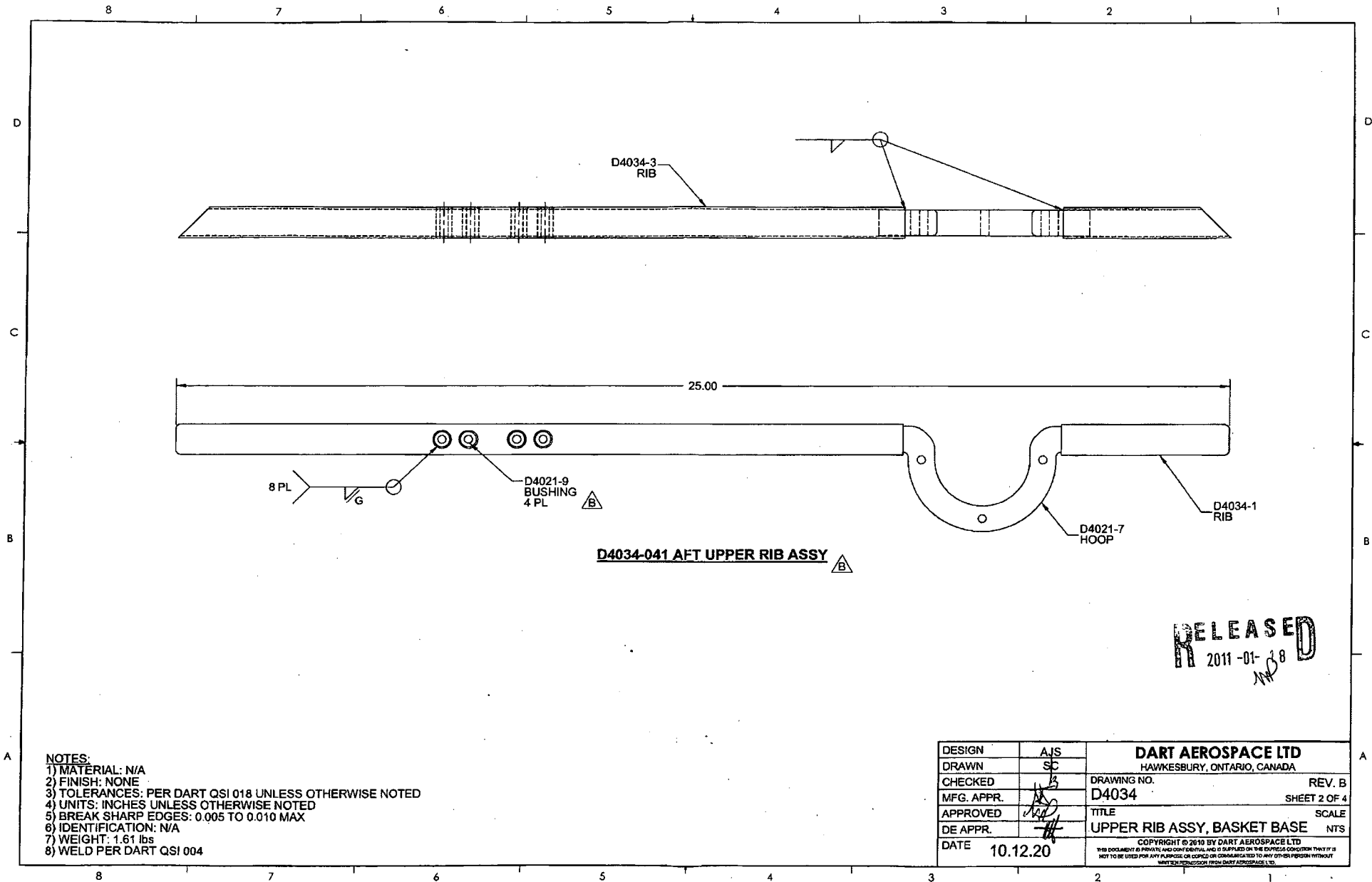
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78329



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.61 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO. <b>D4034</b>	REV. B
MFG. APPR.	JS	SHEET 2 OF 4	
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>UPPER RIB ASSY, BASKET BASE</b>	
DATE	10.12.20	NTS	

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RELEASED  
2011-01-18

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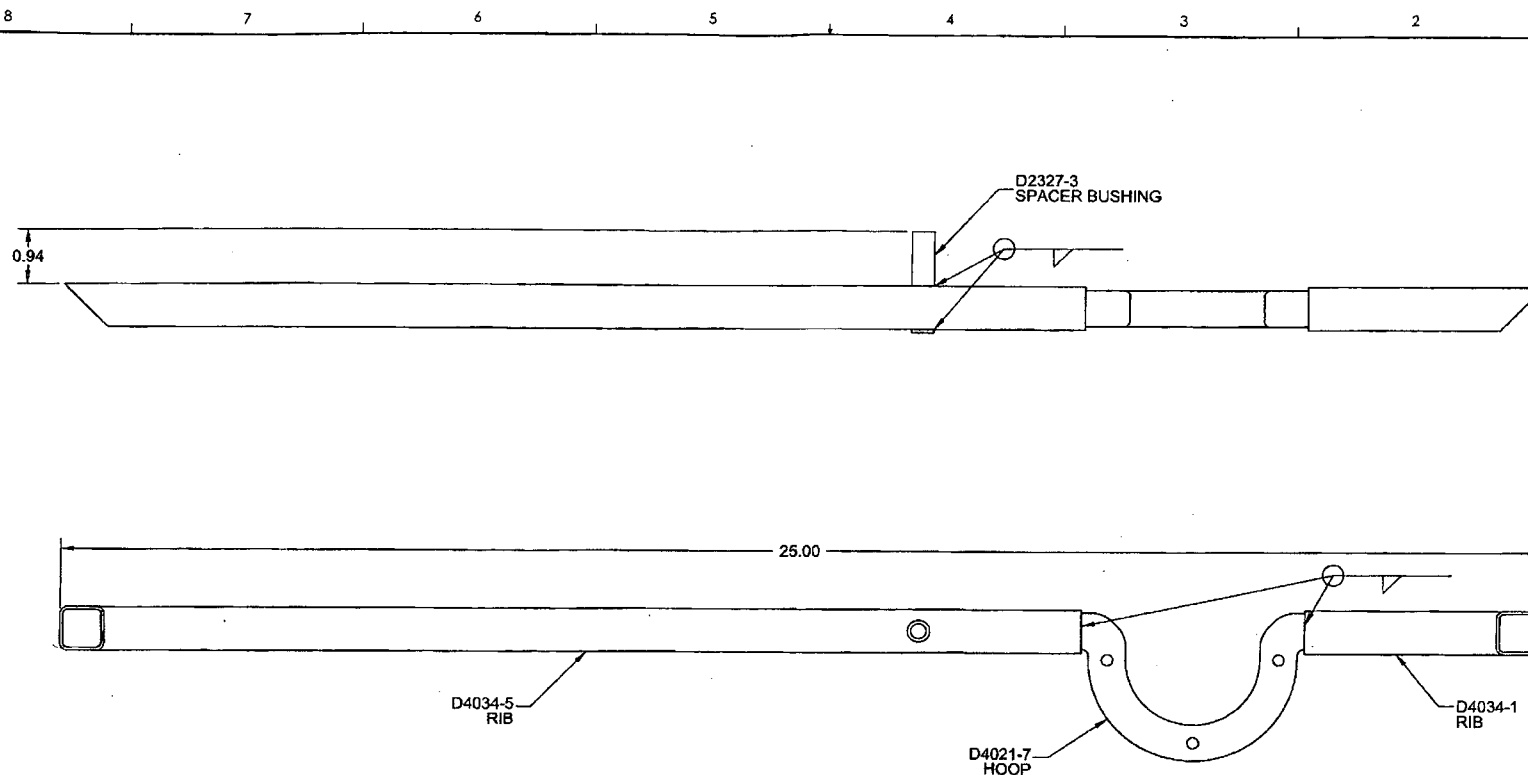
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**NOTE:** Date & initial all entries

78329

**D4034-043 FWD UPPER RIB ASSY**

**RELEASED**  
 2011-01-18  
*JW*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4034</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
DATE	<b>10.12.20</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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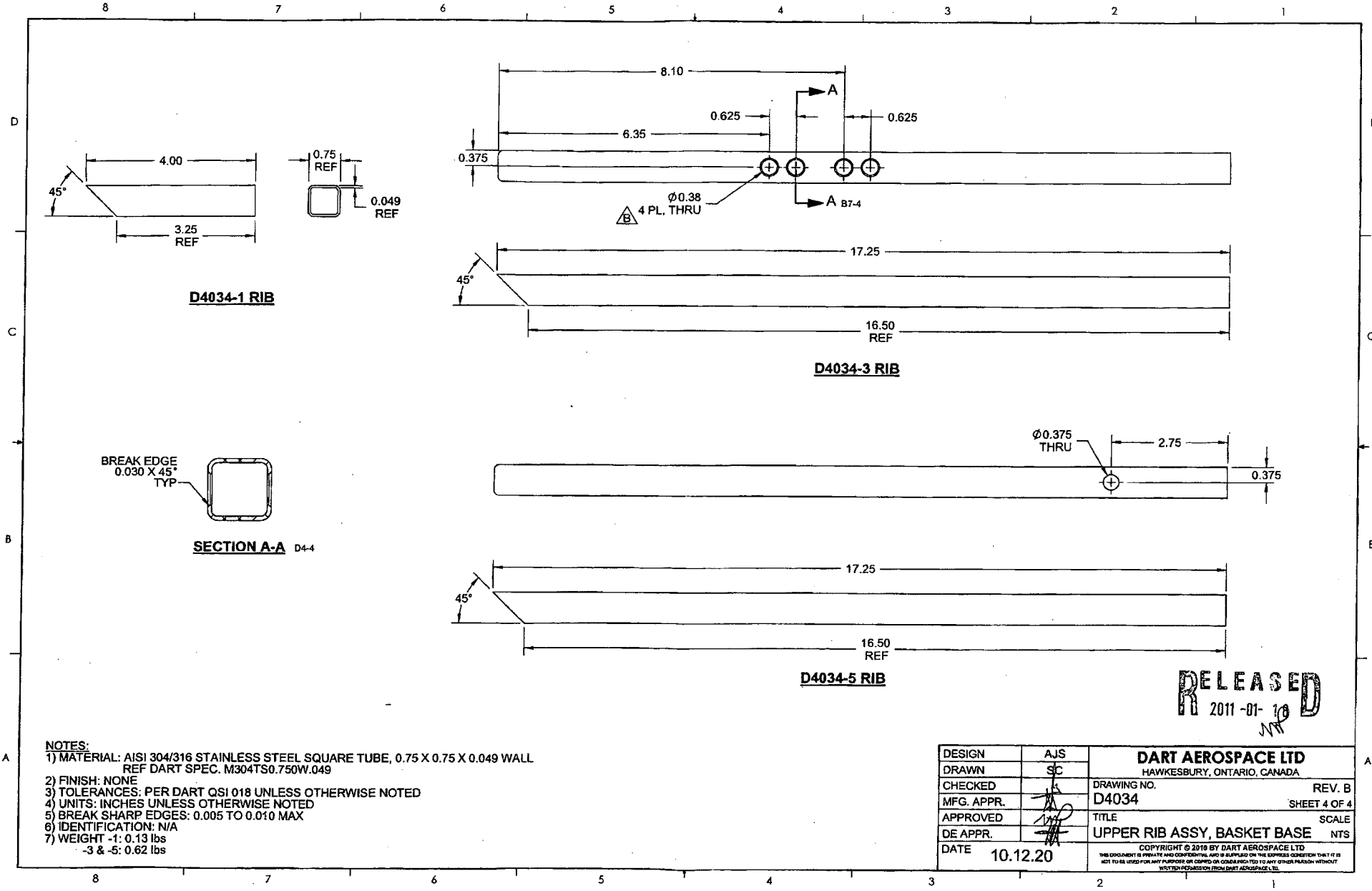
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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